

shp 16/07

Work Order ID 60517

Tuesday, July 13, 2010 11:08:13 AM



Item ID: D3955-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Cover Plate					
Start Date: 7/13/2010	Start Qty: 8.00		Cust Item ID:		
Required Date: 7/20/2010	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: <u> H </u>	Date: <u>10-7-13</u>	Tooling:	Date:	Run	Start	
	QC: <u> </u>	Date: <u> </u>	SPC (Y/N): <u> </u>	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3955								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

ml 10 07 14 (8)

ml 10 07 14 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3955-3

Accept



Setup Start



Revision ID:

Item Name: Cover Plate

Stop



Start Date: 7/13/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/14

(x8)

130

Wing Walk as per dwg QSI005 4.4 Batch M1/4432

0.00



HandFinish

Memo

0.00

Hand Finishing

M 10/07/15

x8

0

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/7/15 (8)

W/O:		WORK ORDER CHANGES							
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Accept



Setup Start



Revision ID:

Item Name: Cover Plate

Stop



Start Date: 7/13/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location 100

0.00



Packaging

Memo

0.00

Packaging

Accepted 7/15 *(S)*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1007-16
MF 10-7-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 13, 2010 11:08:17 AM

Page 1

Work Order ID: 60517

Parent Item: D3955-3

Parent Item Name: Cover Plate



Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	51.5039	0.3553	2.992			



304/316 Sheet .063



Location

MAT

Loc Qty

51.50389474

Loc Code

0

111323

51.5038947

114799

ml 10-07-14

W/O:		WORK ORDER CHANGES					
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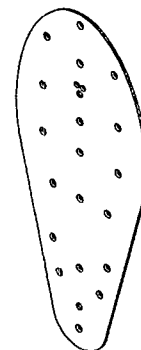
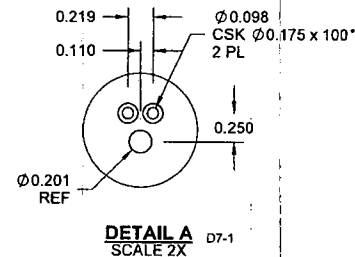
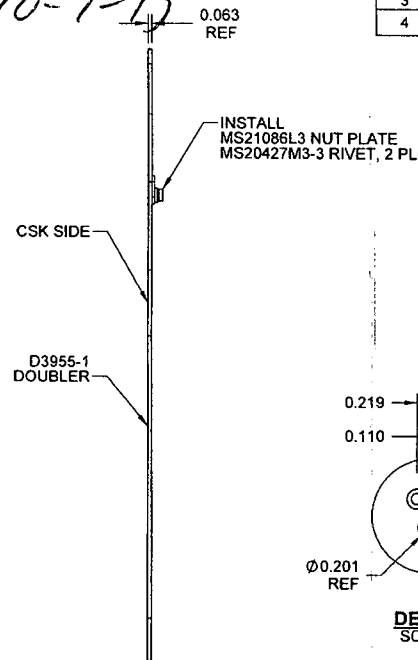
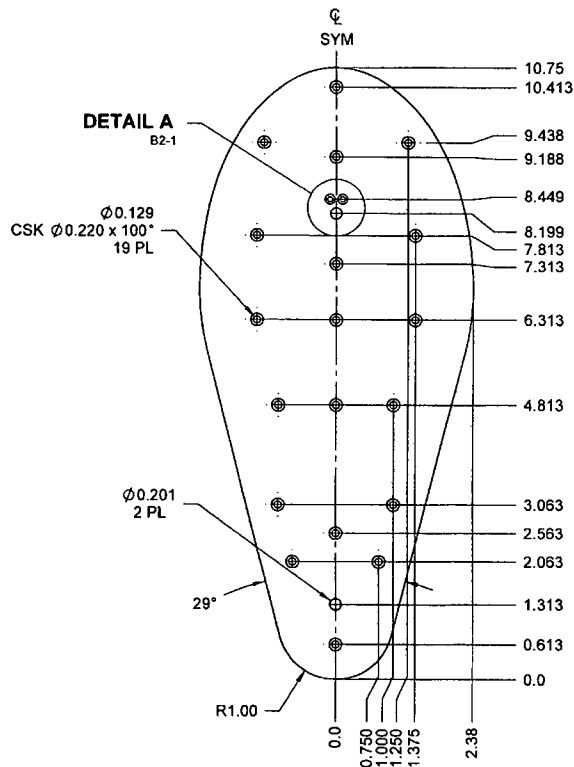
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60517

PR 10-7-13

ITEM	QTY	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-Q-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
07/22/22

A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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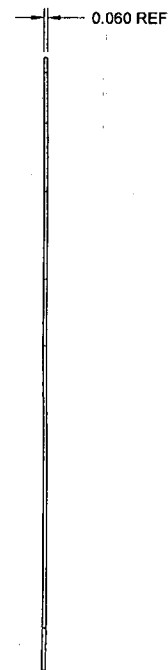
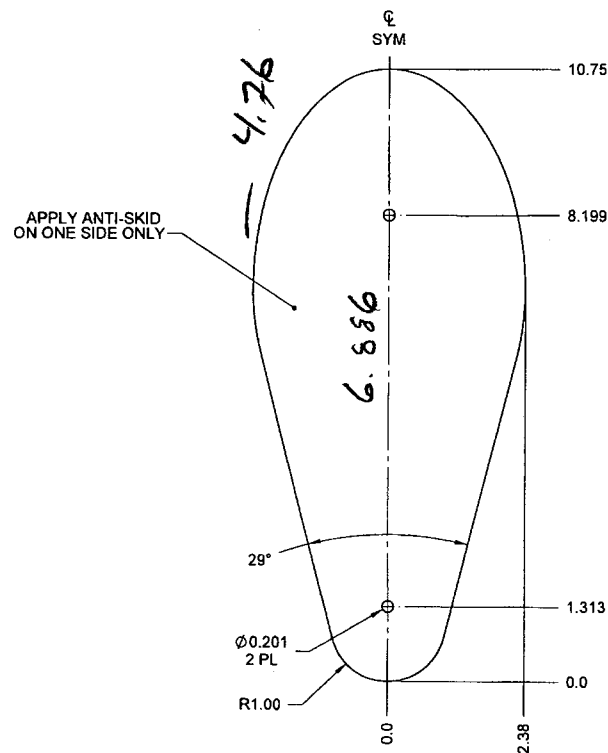
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



wlg 60517

D3955-3 COVER PLATE

RELEASED
09/17/21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
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Dart Aerospace Ltd

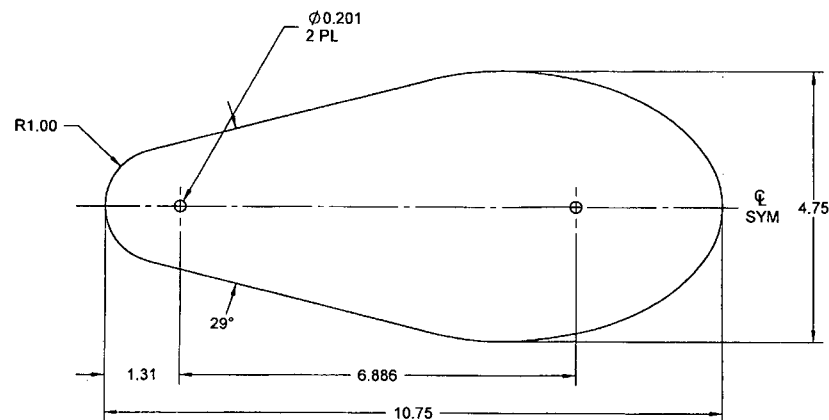
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NOTE: Date & initial all entries



D3955-X PLATE

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304STGA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

W/O 60517

RELEASED
6/6/22 MDD

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MFG. APPR.	<i>[Signature]</i>	D3955	SHEET 3 OF 5
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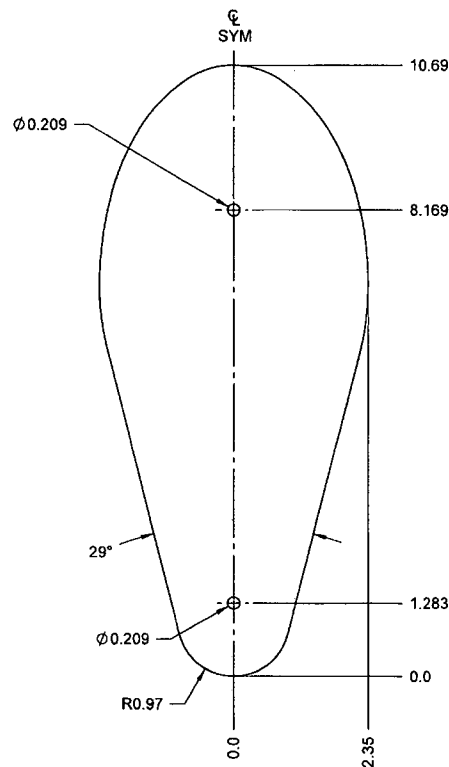
8 7 6 5 4 3 2 1

D

C

B

A



D3955-21 GASKET

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

w/o 605 M

RELEASED
07/07/22 M

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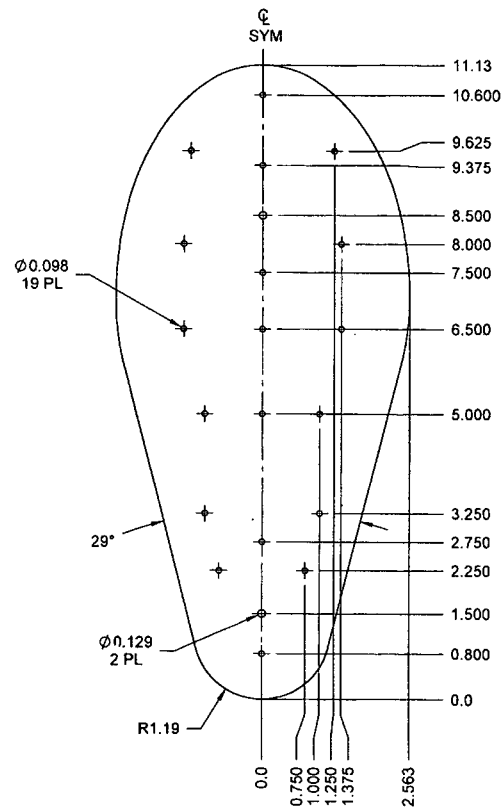
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D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

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MFG. APPR.		D3955	SHEET 5 OF 5
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09/07/21 MB

wlb 60517

Dart Aerospace Ltd

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